

Title (en)

TOOTHED RACK AND METHOD FOR PRODUCING A TOOTHED RACK FOR A STEERING GEAR OF A MOTOR VEHICLE

Title (de)

ZAHNSTANGE UND EIN VERFAHREN ZUR HERSTELLUNG EINER ZAHNSTANGE FÜR EIN LENKGETRIEBE EINES KRAFTFAHRZEUGS

Title (fr)

CRÉMAILLÈRE ET PROCÉDÉ DE FABRICATION D'UNE CRÉMAILLÈRE POUR UN MÉCANISME DE DIRECTION D'UN VÉHICULE AUTOMOBILE

Publication

**EP 3481700 A1 20190515 (DE)**

Application

**EP 17735127 A 20170704**

Priority

- DE 102016212304 A 20160706
- EP 2017066624 W 20170704

Abstract (en)

[origin: WO2018007378A1] The invention relates to a method for producing a toothed rack (2) for a steering gear of a motor vehicle, which toothed rack has at least one toothed section (21) having a set of teeth (22) and at least one shaft section (24), wherein separate segments, comprising at least one bar-shaped toothed segment (61) and one shaft segment (62), are provided, aligned on a common longitudinal axis (L), and connected to each other at a joint (27). In order to make the production process of assembled toothed racks more efficient, the method according to the invention comprises the following steps: providing a raw-material piece (3) having a piece length of a multiple of a segment length (ls), performing thermal through-feed hardening of the raw-material piece (3) over a multiple of the segment length (ls) in order to produce a hardened segment semi-finished product (31), cutting a hardened segment (32) to length from the hardened segment semi-finished product (31), providing a further segment, joining the hardened segment (32) to a further segment.

IPC 8 full level

**B62D 3/12** (2006.01); **B21K 1/04** (2006.01)

CPC (source: EP US)

**B21K 1/767** (2013.01 - EP); **B23F 9/00** (2013.01 - US); **B62D 3/126** (2013.01 - EP US); **F16H 55/06** (2013.01 - US); **F16H 55/26** (2013.01 - US)

Citation (search report)

See references of WO 2018007378A1

Cited by

DE102021109639B3

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

Designated extension state (EPC)

BA ME

DOCDB simple family (publication)

**DE 102016212304 A1 20180111**; **DE 102016212304 B4 20180222**; CN 109415083 A 20190301; CN 109415083 B 20211001; EP 3481700 A1 20190515; EP 3481700 B1 20200819; ES 2829329 T3 20210531; PL 3481700 T3 20210125; US 11298765 B2 20220412; US 2020223001 A1 20200716; WO 2018007378 A1 20180111

DOCDB simple family (application)

**DE 102016212304 A 20160706**; CN 201780042060 A 20170704; EP 17735127 A 20170704; EP 2017066624 W 20170704; ES 17735127 T 20170704; PL 17735127 T 20170704; US 201716315956 A 20170704